

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023874**Date Inspected:** 18-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

**Trial Assembly**

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13CE

PCMK: SEG3007AH

Weld No: 030

Welder: 043661

Weld Repair No. B-WR20583

WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 13CE

PCMK: CA3014A

Weld No: 104,108

Welder: 058102

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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Weld Repair No. B-WR20542  
WPS-345-SMAW-4G(4F)-FMC-Repair-1

Components; OBG 14E

PCMK: SEG3019C

Weld No: 001

Welder: 216086

Weld Repair No. B-WR21037

WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E

PCMK: DP3160-001

Weld No: 381,012,338,211

Welder: 215553, 044779

Weld Repair No. B-WR20985

WPS-345-SMAW-3G(3F)-FMC-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BE

PCMK: SA7009-001

Weld No: 003,005

Welder: 050977

WPS-B-T-2231-ESAB

Components; OBG 13BE

PCMK: SA7009-002

Weld No: 003,005

Welder: 050977

WPS-B-T-2231-ESAB

Components; OBG 13BE

PCMK: SA7009-003

Weld No: 003,005

Welder: 050977

WPS-B-T-2231-ESAB

Components; OBG 13BE

PCMK: SA7009-004

Weld No: 003,005

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## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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Welder: 050977  
WPS-B-T-2231-ESAB

Components; OBG 13BE  
PCMK: 3012A-001  
Weld No: 045,046,047,048  
Welder: 055491  
WPS-B-T-2233-ESAB

Components; OBG 13BE  
PCMK: SEG3019AJ  
Weld No: 139,140,142,143,144  
Welder: 067877  
Weld Repair No. B-WR21029  
WPS-345-FCAW-3G(3F)-FMC-Repair-1

Components; OBG 13BE  
PCMK: SEG3019AJ  
Weld No: 139,140,142,143,144  
Welder: 067877  
Weld Repair No. B-WR21029  
WPS-345-FCAW-3G(3F)-FMC-Repair-1

Components; OBG 13BE  
PCMK: SEG3019AJ  
Weld No: 205,200,195,190,185  
Welder: 051356  
Weld Repair No. B-WR21029  
WPS-345-FCAW-3G(3F)-FMC-Repair-1

Components; OBG 13BE  
PCMK: SEG3019D-1  
Weld No: 015,016,017,018,019,020  
Welder: 501946  
WPS-B-T-2233-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“No relevant conversations.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

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remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt,Kelly	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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